



# Work Order ID 55323

January 13, 2010 10:22:40 AM


Page 1

Item ID:	D2143	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	1/13/10	Start Qty:	20.00		Cust Item ID:	
Required Date:	1/20/10	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>RP</i>	Date:	<i>10-1-13</i>	Tooling:	Date:	Run	Start	
	QC:		Date:		SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2143	Rev C1								

100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
	1-Cut as per Dwg D2143		Dwg Rev:	<i>C1</i>	Prog Rev:	<i>C1</i>			
	Deburr if necessary								


*5052.040*

*Deburr = 7 m. A 10/6/126*


*IB 10-1-21*

*(27X)*

*(27)*

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
	Quality Control								

*IB 10-1-21*

120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
	Quality Control								

*=> 8.10.126*

*center*

*(26)*

*Ph =>*

W/O: 55323

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/26	#120	Took Qty #1 For inspection template	S	10/01/26	#1		S 10/01/26

Part No: D2143 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 55323

January 13, 2010 10:22:40 AM



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Item ID: D2143

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 1/13/10

Start Qty: 20.00



Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

Tumble and Deburr

n/a

0.00

140



NC BRAKE

0.00

Brake NC

Memo

Brake NC

Bend as per Dwg D2143

0.00

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

⇒ 8/10/10

24

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 55323

January 13, 2010 10:22:40 AM

Page 3

Item ID: D2143

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 1/13/10 Start Qty: 20.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-02-01 (26) 0

HandFinish

Memo

0.00

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

=> JH 10-02-01

(26) 0

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00 AM OVEN TEMPERATURE:  
10:30 AM FINISH TIME: 320°F

180

QC3- Inspect Part Finish

0.00

BR 10-02-4

(26) 0

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55323**

January 13, 2010 10:22:40 AM

Page 4

Item ID: D2143

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 1/13/10 Start Qty: 20.00

Required Date: 1/20/10 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: *190*

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/2/11 26**10/2/11**MF**10-2-9.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January 13, 2010 10:22:44 AM

Page 1

Work Order ID: 55323



Parent Item: D2143

Parent Item Name: Hinge Bracket

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP ☐ C ☐ 00.05.18 Added inspection level 8 ☐ EC  
IPP Rev:D Now on WaterJet 06-10-15 JLM ☐

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	116.1568	1.3895	1.9		



5052-H32 .040 Sheet



RB 10-1-21

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

116.1568

101875

6.625

104921

3.3568

106900

2

107513

4.5

109058

35.675

113123

64

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
1'  
113123

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 55323
<b>Description:</b> HINGE BRACKET		<b>Part Number:</b> D2143
<b>Inspection Dwg:</b> D2143 <b>Rev:</b> C1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .171	+ .005 - .001	.173	✓			
Ø .257	+ .006 - .001	.260	✗			
.340	+/- .010	.339	✗			
.625	+/- .010	.622	✗			
1.000	+/- .010	1.001	✗			
1.083	+/- .010	1.085	✗			
1.660	+/- .010	1.660	✓			
2.312	+/- .010	2.305	✗			
2.844	+/- .010	2.844	✗			
.746	+/- .010	.747	✗			
1.104	+/- .010	1.106	✗			
1.659	+/- .010	1.660	✗			
2.213	+/- .010	2.217	✗			
2.572	+/- .010	2.570	✗			
3.317	+/- .010	3.321	✗			
2.656	+/- .010	2.659	✗			
.661	+/- .010	.666	✗			
.040	+/- .010	.040	✗			

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-1-21	<b>Date:</b> 10/6/26	<b>Date:</b>	N/A

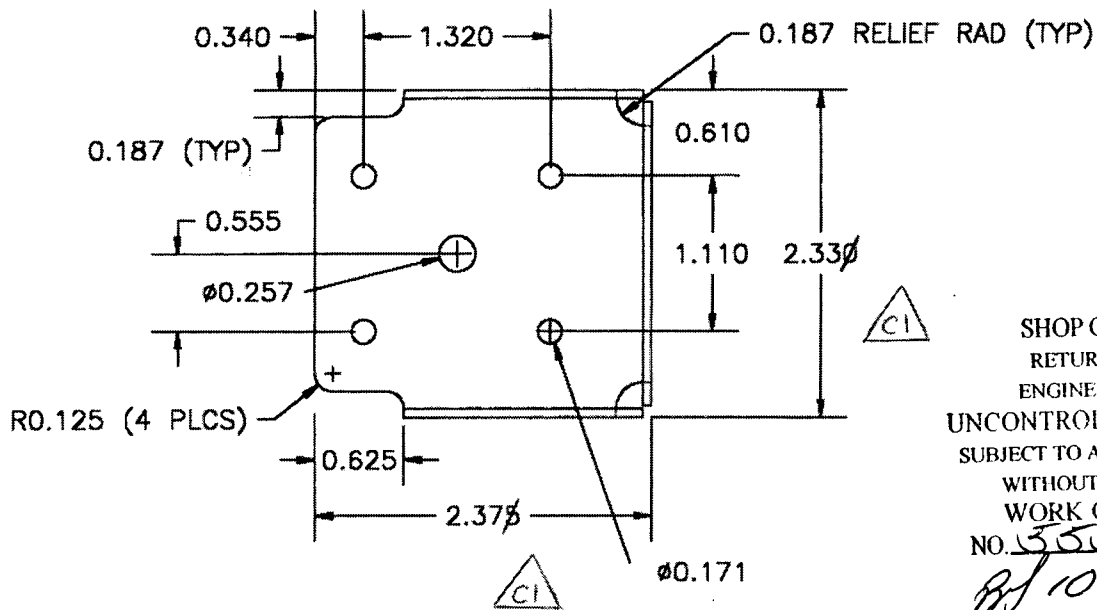
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**DART**

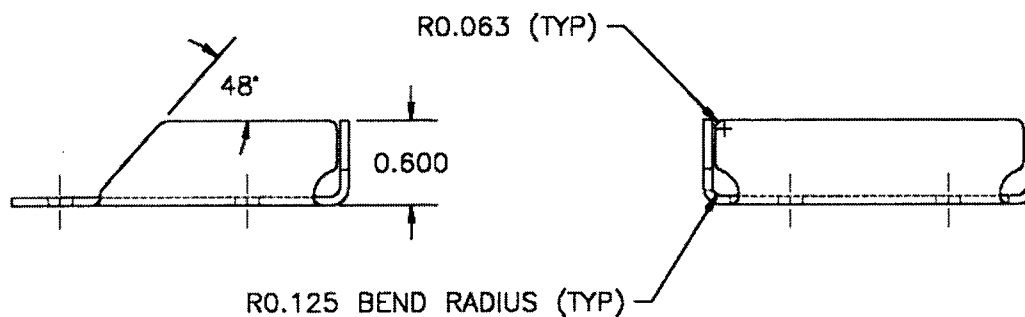


**RELEASED**  
960620 (B)

DESIGN	J BRADLEY	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	<i>Br</i>	APPROVED	<i>Br</i>	DRAWING NO.	D2143
DATE	92:07:10	TITLE	HINGE BRACKET	REV. C	SHEET 1 OF 2
				SCALE	
	B	96.06.06	ADD FLAT PATTERN		
	C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK		
CI	4.04.06.15 UPDATE DIMENSIONS				



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55323  
*10-1-13*



MATERIAL: 5052-H34, 0.040 THICK  
FINISH: WHITE POWDER COAT HI-GLOSS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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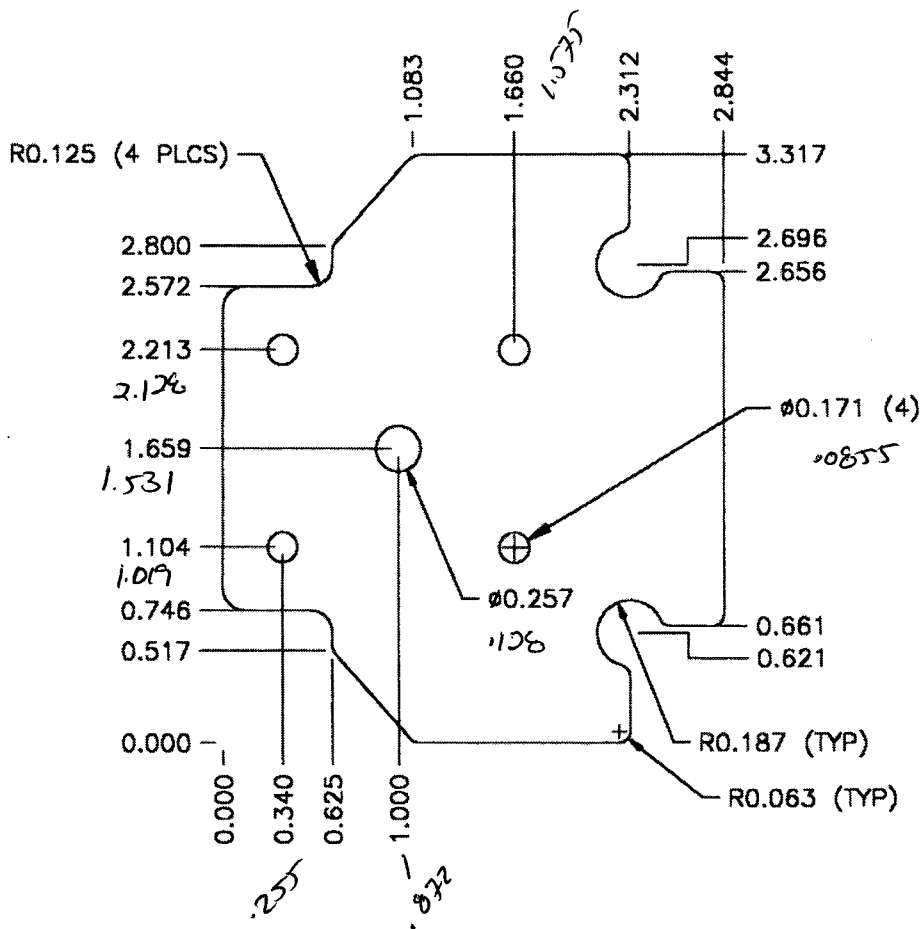
**NOTE:** Date & initial all entries

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. c
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE	TITLE	SCALE	
95:10:18	HINGE BRACKET FLAT PATTERN	1:1	

RELEASED  
96 66 20 62



MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries